

Work Order ID 124877

124877

Page 1

Thursday, September 25, 2014 1:06:28 PM

Item ID: D206-642-541,

Accept

N900040100

Setup Start *NS1*

Revision ID: UR

OK 9/14/25

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 9/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 9/25/25

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Rate Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								

100 Document Control 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D206-642-541

CHG005

N/A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	<table style="width:100%;"> <tr> <td style="width:33%;"> AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width:33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width:33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width:33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***

Start Date: 9/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M125127

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DGL 14-9-26

> BE14-10-14

BE14-10-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Item ID: D206-642-541

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N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop

NS2

Start Date: 9/25/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00							
Quality Control									
116	QC10- Inspect visual per QSI004- ground welds	0.00							
116									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

DAS
03
9-89

14-10-15

DAS
9
9-89

14-10-15

14-10-15

DGL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877

Thursday, September 25, 2014 1:06:28 PM

124877

Page 4

Item ID: D206-642-541

Accept

N19000040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***Start Date: 9/25/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
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130

QC

Memo

0.00

Quality Control

1 0 14-10-16

150

150

Skid tubes

Skid tubes

Skid tubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 130227Sikaflex expire date: 18-02-05Start: _____ Time: 11:30

Finish: _____ Time: _____

(Adhere for 12 hours)

DGC 14-10-16

DGC 14-10-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY							
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube		General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function		☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Work Order ID 124877

Thursday, September 25, 2014 1:06:28 PM

124877

Page 5

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***Start Date: 9/25/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
160	QC5- Inspect part completeness to step on W/O	0.00								
160										
QC	Memo	0.00				1	0	14-11-03		18
Quality Control										9-89

170

170

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Debur3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

14-11-3 J4/DGL

14-11-3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	<table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877

124877

Page 6

Thursday, September 25, 2014 1:06:28 PM

Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-29
180	QC5- Inspect part completeness to step on W/O	0.00								
180										
QC	Memo	0.00								
Quality Control										
190		0.00								
190										
Skidtubes	Skidtubes	0.00								
Skidtubes	Memo	0.00								
	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>M130137</u> <u>BE 14-11-04</u>									
	3-Grind cross bolt welds flush as per Dwg D3274. ***INSPECT FOR PIN HOLES IN WELD***									
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.									

Handwritten signature and date: 14-11-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 7

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***Start Date: 9/25/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 Req'd Qty: 1.00 ***1***

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Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				①	14-11-05		DAS 9 9-89
210 *210* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				②	14-11-05		DAS 9 9-89
220 *220* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo <u>Re-afodine tube as per QSI 005 section 4.1.2.1 do not acid etch</u>	0.00 0.00				12	9/11/14		14/11/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877

Thursday, September 25, 2014 1:06:28 PM

124877

Page 8

Item ID: D206-642-541
 Revision ID: U/R
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00
 Required Date: 9/25/2014 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

SprayPaint
 Spray Painting

Memo

0.00

Make sure Nut Plate Thread is protected using paint screw,.

1- PRIME AS PER DWG AND QSI 005 4.2
 PRIMER PRC DESOTO 515X349 BATCH: 128975

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
 PAINT BATCH: 129 777

1 CP 14.11.10

240

240

QC
 Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

1x of all sub v **DAS 15 9-09**

244

244

HandFinish
 Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M13078.00

Memo

0.00

W. of all sub v

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877

Thursday, September 25, 2014 1:06:28 PM

124877

Page 9

Item ID: D206-642-541 **Accept** ***N19000040100*** **Setup** **Start** ***NS1***
Revision ID: U/R
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) **Stop** ***NS2***
Start Date: 9/25/2014 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/25/2014 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
246	QC3- Inspect Part Finish	0.00							DAS 38 9-29 14-11-12
246									
QC	Memo	0.00							
Quality Control									
250		0.00							
250	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing									

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 11122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 1430277
Sikaflex expire date: 151205

12 of 14 14/11/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877

Thursday, September 25, 2014 1:06:28 PM

124877

Page 10

Item ID: D206-642-541
 Revision ID: U/R
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00
 Required Date: 9/25/2014 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Dwg Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								
270		0.00							
270	HAND FINISHING RESOURCE #1								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								
	2-Install ring as per Dwg D3274								
	A/RSikaflex-291 <u>M130227</u>								
	Sikaflex expire date: <u>15108</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.								
	A/RSikaflex-291 <u>M130227</u>								
	Sikaflex expire date: <u>15108</u>								

DAS 34 9.89

1 of 14-11-12

1 of 14-11-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124877***124877***

Page 11

Thursday, September 25, 2014 1:06:28 PM

Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
280	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
280 QC Quality Control	Memo	0.00							14-11-12
290	Identify as per dwg & Stock Location: _____	0.00							DAS 86 9-89
290 Packaging Packaging	Memo	0.00							PAP 12 8599 FEB 18 2015
300	QC21- Final Inspection - Work Order Release	0.00							
300 QC Quality Control	Memo	0.00							15/2/19 MS-2-18

Picklist Print

Thursday, September 25, 2014 1:06:31 PM

Page 1

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKI/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
 REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I
 14.04.28 AS PER ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3274-041BENT

Manufactured

No

110

Each

10.0000

1

1

D3274-041BENT

Skidtube Assembly 206

**

DGC 14-9-25

Location

Loc Qty

Loc Code

LG002

10

113682

1

120287

9

D4956-15

Manufactured

No

270

Each

14.0000

1

1

D4956-15

Stainless Steel Wearplate Fwd

**

14/9/11

Location

Loc Qty

Loc Code

FP002

14

120326

2

122996

12

D4956-23

Manufactured

No

270

Each

10.0000

1

1

D4956-23

Stainless Steel Wearplate Center Fwd

**

14/9/11

Location

Loc Qty

Loc Code

FP002

10

121755

10

Picklist Print

Thursday, September 25, 2014 1:06:31 PM

Page 2

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D4956-35 Manufactured No 270 Each 12.0000 Start Qty: 1.00 Required Qty: 1.00

D4956-35

Stainless Steel Wearplate Aft

**

Location	Loc Qty	Loc Code
FP002	12	
120577	1	
121975	11	

D4956-39 Manufactured No 270 Each 9.0000 1 1

D4956-39

Stainless Steel Wearplate Center Aft

**

Location	Loc Qty	Loc Code
FP002	9	
121857	9	

D3285-1 Manufactured No 110 Each 5.0000 1 1

D3285-1

Cap

**

Location	Loc Qty	Loc Code
LG001	5	
108052	5	

D3282-041 Manufactured No 150 Each 7.0000 1 1

D3282-041

Float Web (206L/407)

**

Location	Loc Qty	Loc Code
LG002	7	
113149	1	
119524	6	
125295		

8/14/10-14
8/2/820 x1

JGC 14-10-30.

Thursday, September 25, 2014 1:06:32 PM

Shop Packet Print

Page 2

Picklist Print

Thursday, September 25, 2014 1:06:32 PM

Page 3

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D2649

Manufactured No

190 Each

Start Qty: 1.00
415.0000 12 12

Required Qty: 1.00

D2649

Cross Bolt Spacer

**

BE14-11-04

Location

Loc Qty

Loc Code

LG

203

123099

203

12

LG001

212

107906

3

112728

6

113811

2

120508

195

90497

6

D3275-1

Manufactured No

190 Each

191.0000 12 12

D3275-1

Crossbolt Spacer

**

BE14-11-04
*B125432 *8*

Location

Loc Qty

Loc Code

LG001

191

113246

1

113851

62

114877

65

121868

1

121974

62

4

CR3212-4-03

Purchased No

250 Each

998.0000 2 2

CR3212-4-03

Cherry Rivet

**

ell *wl wl n*

Location

Loc Qty

Loc Code

ST321

998

114889

1

119017

700

m114859

100

m123265

197

22

Thursday, September 25, 2014 1:06:32 PM

Shop Packet Print

Page 3

Picklist Print

Thursday, September 25, 2014 1:06:32 PM

Page 4

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3415-041 Manufactured No

250 Each

19.0000 Start Qty: 1.00 1

Required Qty: 1.00

D3415-041

Nut Plate

**

all white

Location

Loc Qty

Loc Code

ST037

19

113764

19

X1
2

CCR264SS3-3

Purchased No

250 Each

431.0000 2

CCR264SS3-3

Cherry Rivet

**

all white

Location

Loc Qty

Loc Code

ST321

431

113973

26

m126282

47

m126333

70

m128636

88

m128818

200

X2

ALS4-1032-130

AELS4-1032-130 Purchased

No

250 Each

4,073.000 78

78

A1 S4-1032-130

Rivnut

**

all white

Location

Loc Qty

Loc Code

ST267

4073

M126109

57

M128211

48

M128649

3968

X38

Picklist Print

Thursday, September 25, 2014 1:06:32 PM

Page 5

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3537-3

Manufactured No

270

Each

60.0000

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Wearpad

**

lll *12/1/14*

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

12

111825

1

113789

1

115122

10

FP002

40

120646

40

x1

D3537-1

Manufactured No

270

Each

78.0000

9

9

D3537-1

Wearpad

**

lll *12/1/14*

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

60

113839

4

120644

37

120645

18

93945

1

B125 679

x9

Picklist Print

Thursday, September 25, 2014 1:06:32 PM

Page 7

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3672-1

Manufactured No

270 Each

Start Qty: 1.00
955.0000 2 2

Required Qty: 1.00

D3672-1

Washer, Phenolic

all values

Location

Loc Qty

Loc Code

FG	10
85222	10
ST055	945
103845	4
<u>113581</u>	474
120116	421
80369	34
99099	12

<i>x2</i>

AN3C4A

Purchased No

270 Each

1,103.000 80 80

AN3C4A

Bolt

all values

Location

Loc Qty

Loc Code

FG	20
122814	20
ST350	1083
124221	12
M127410	1
M127832	62
M128606	32
M128634	8
M128739	4
M128879	71
<u>M129520</u>	893

M130716

<i>x16</i>

<i>x64</i>

Picklist Print

Thursday, September 25, 2014 1:06:32 PM

Page 8

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

AN4C5A

Purchased

No

270

Each

56.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

AN4C5A

Bolt

all wheel

Location

Loc Qty

Loc Code

ST355

56

122599

3

123265

1

M127410

10

M128403

42

✓

D2646

Manufactured

No

270

Each

57.0000

1

1

D2646

Aft Cap

all wheel

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

2

107857

1

110816

1

113830

2

114495

6

FP002

41

119656

41

✓

Picklist Print

Page 9

Thursday, September 25, 2014 1:06:32 PM

Work Order ID: 124877

124877

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3413-1

Manufactured No

270

Each

33.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3413-1

O-Ring

Location

Loc Qty

Loc Code

ST525

33

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

10

X1

Thursday, September 25, 2014 1:06:32 PM

Shop Packet Print

Page 9

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2648	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4956-15	WEARSHOE
1	1	D4956-23	WEARSHOE
1	1	D4956-35	WEARSHOE
1	1	D4956-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C418	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

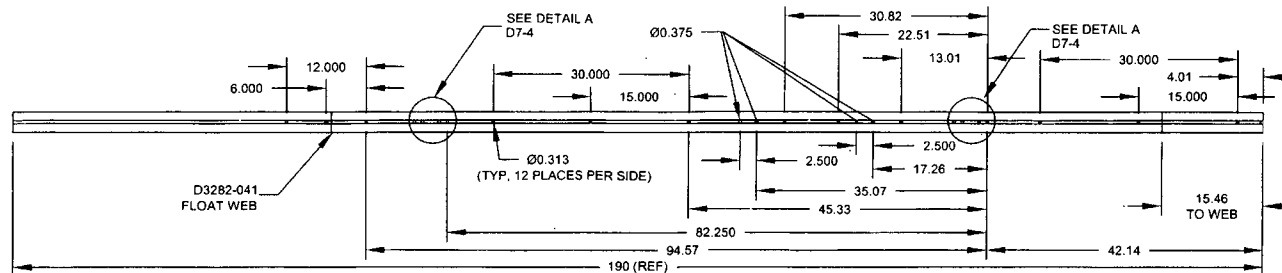
1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/281.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.



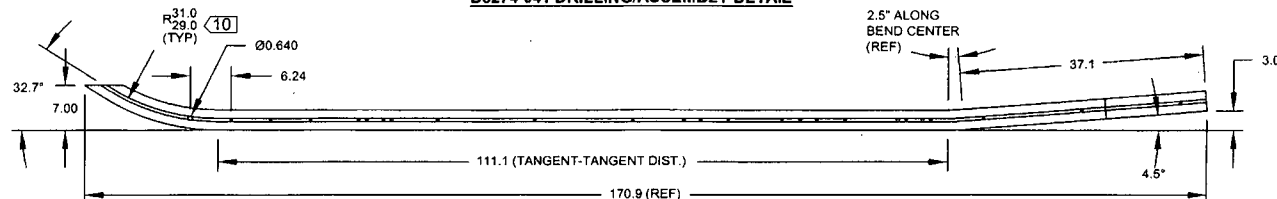
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124877 MLC
140925

RELEASED
2014-05-26
mld

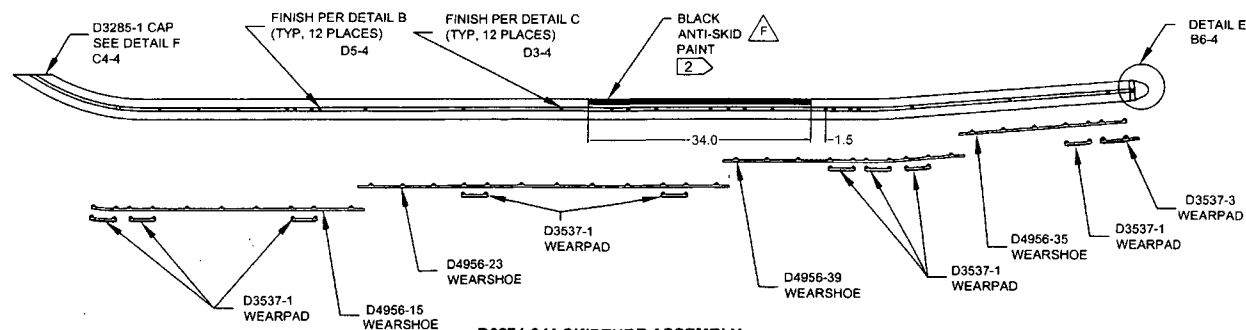
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-842 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -043; NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	



D3274-041 DRILLING/ASSEMBLY DETAIL



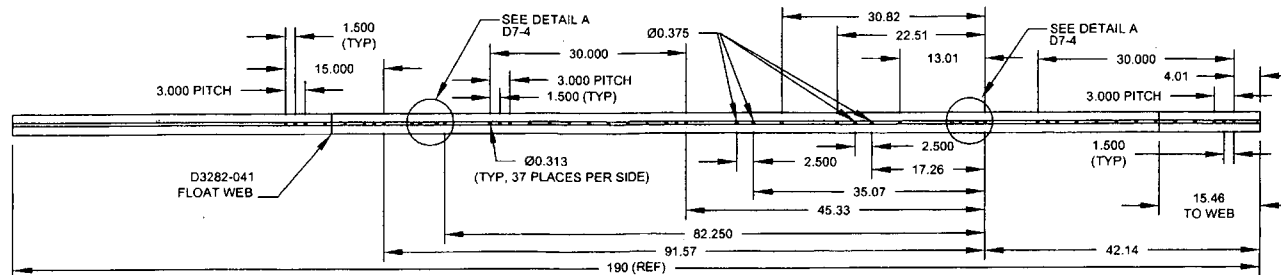
D3274-041 BEND/DRILLING DETAIL



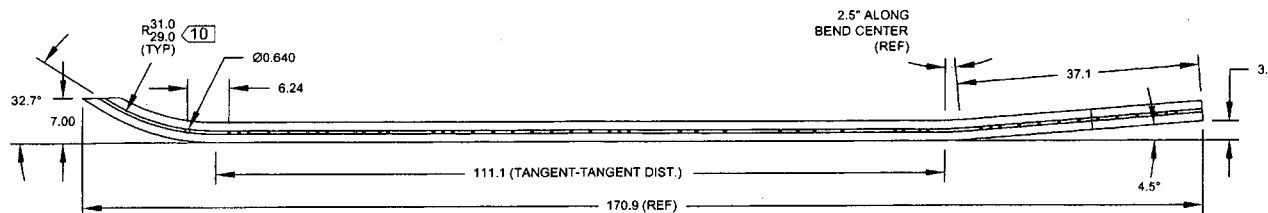
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

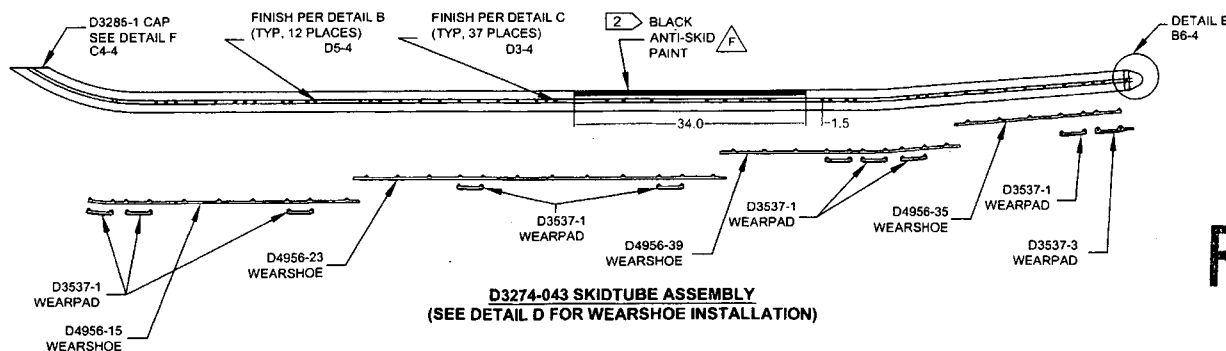
DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. F
MFG. APPR.	AD	D3274	SHEET 2 OF 4
APPROVED	WTH	TITLE	SCALE
OE APPR.		SKIDTUBE ASSEMBLY	NTS
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D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

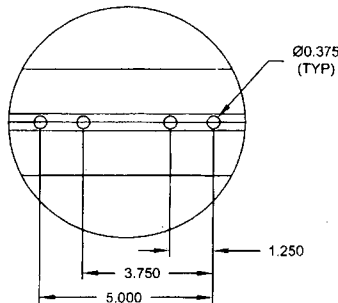


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

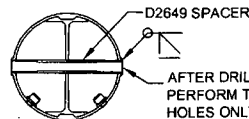
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DRAWN	DB	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	4.04.15
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

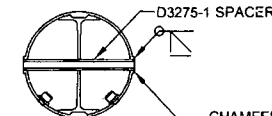
FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313x0.75 DEEP

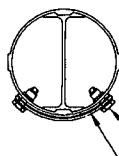
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

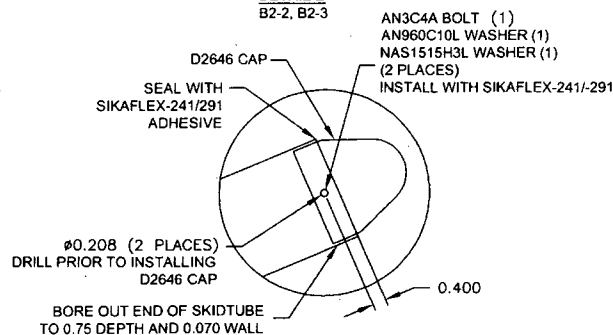
DETAIL D
A4-2, A4-3



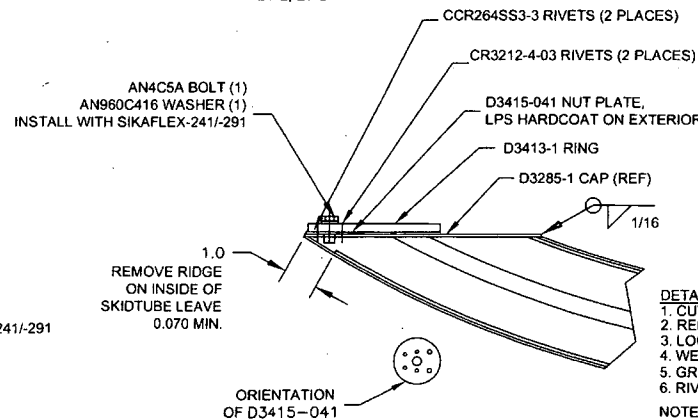
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	g.p.	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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Linda Lacelle

From: Mike Petsche
Sent: June-24-14 3:17 PM
To: Linda Lacelle
Subject: RE: D206-642-541 floats

Personally, I say just assemble them. The powder coat won't last long anyway

From: Linda Lacelle
Sent: Tuesday, June 24, 2014 12:40 PM
To: Mike Petsche; David Shepherd; Chris Provencal
Cc: Nigel Forbes
Subject: RE: D206-642-541 floats

May I proceed with assembly? We have about 10 on the go right now. I really don't want to wait to have more made...we have 79 of the painted in stk of D3537-1 and 43 of the D3537-3's. shall I get all the w/o's off the shop floor and remove the powder coat? Do I need someone to sign this off?
LL

From: Mike Petsche
Sent: June-24-14 12:38 PM
To: Linda Lacelle; David Shepherd; Chris Provencal
Cc: Nigel Forbes
Subject: RE: D206-642-541 floats

Meh....not really. But ideally we should remove the powder coat from the dwg

From: Linda Lacelle
Sent: Tuesday, June 24, 2014 12:36 PM
To: David Shepherd; Mike Petsche; Chris Provencal
Cc: Nigel Forbes
Subject: D206-642-541 floats

Question for anyone that can answer me:

The new wearplates D4956-XX that replace the D3535-XX are SS unpainted, but the wearpads D3537-1/-3 are painted, does this matter?